

Work Order ID 76273

76273

Page 1

Tuesday, November 08, 2011 1:28:15 PM

Item ID: D3639-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Doubler
Start Date: 11/8/2011 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 11/22/2011 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: M.L.J Date: 11/11/08 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3639	Rev A								

100

0.00

100

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3639 Dwg Rev: A Prog Rev: A 2-
Deburr if necessary

7024 .050

12-3-9

7

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

12-3-9

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

5-2/03/09

7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3639-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Doubler
 Start Date: 11/8/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 11/22/2011 Req'd Qty: 4.00 ***4*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	NC BRAKE Memo Form as per Dwg D3639	0.00 0.00	SB 12/03/15				(7)		
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00					(X7)		
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	XCPM 12/03/15						

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NOTE: Date & initial all entries

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Tuesday, November 08, 2011 1:28:16 PM

N900040100

Setup Start *NS1*

Stop *NS2*

4

Cust Item ID:

Start Date: 11/8/2011 **Start Qty:** 4.00

Required Date: 11/22/2011 **Req'd Qty:** 4.00

4

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: S7244 0.00

170

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release	0.00
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180

QC

Memo


0.00

Quality Control

12/3/15

Number 725

⑦x Sp 12-03-16

12/3/16 

11203-16

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Tuesday, November 08, 2011 1:28:19 PM

Page 1

Work Order ID: 76273

76273

Parent Item: D3639-1

D3639-1

Parent Item Name: Doubler

Start Date: 11/8/2011

Required Date: 11/22/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.050

Purchased

No

100

sf

83.1000

0.239

1.006316

2,

M2024T3S 050

**

BIL-3-9

2024-T3 .050 sheet

Location

Loc Qty

Loc Code

MAT22

83.1

117684

83.1

117684



W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	76273
Description: Doubler		Part Number:	D3639-1
Inspection Dwg: D3639 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.625	+0.008/-0.001	.625	2		✓ RBZ	
Ø0.191	+0.005/-0.001	.192	2		✓	
Ø0.098	+0.004/-0.001	.098	2		✓	
0.69	+/-0.030	.686	2		✓	
1.59	+/-0.030	1.591	2		✓	
2.49	+/-0.030	2.492	✓		✓	
3.39	+/-0.030	3.393	2		✓	
3.990	+/-0.010	3.991	2		✓	
4.990	+/-0.010	4.991	2		✓	
5.19	+/-0.030	5.191	✓		✓	
6.99	+/-0.030	6.989	✓		✓	
8.64	+/-0.030	8.641	✓		✓	
0.45	+/-0.030	.453	✓		✓	
0.710	+/-0.010	.711	✓		✓	
2.000	+/-0.010	2.003	✓		✓	
2.75	+/-0.030	2.75	✓		✓	
3.55	+/-0.030	3.551	✓		✓	
4.00	+/-0.030	4.003	✓		✓	
2.000	+/-0.010	2.004	✓		✓	
2.590	+/-0.010	2.590	✓		✓	

Measured by: RB	Audited by: J	Prototype Approval:	N/A
Date: 12-3-9	Date: 12/3/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.19	New Issue	KJ/EC/DD	AS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

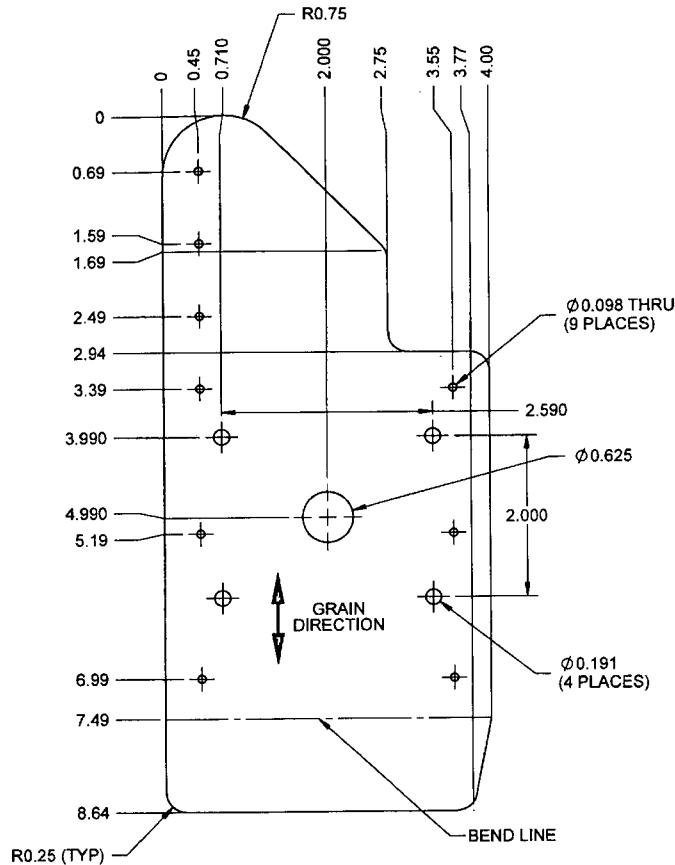
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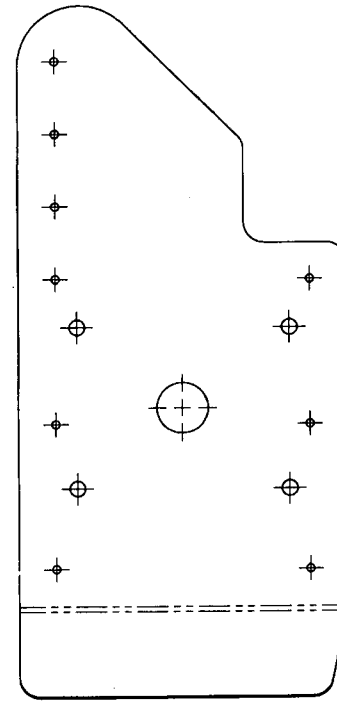
C

B

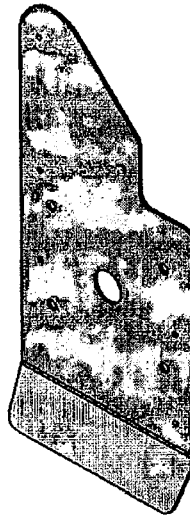
A



D3639-1F FLAT PATTERN
(D3639-2F OPPOSITE)



D3639-1 DOUBLER
(WAS GENEVA P/N G10604-3)
D3639-2 OPPOSITE
(WAS GENEVA P/N G10604-6)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 76273

RELEASED
07.07.27

- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-1/-2" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.14 lbs

A	NEW ISSUE; REPLACES G10604	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS		
DRAWN	LE		
CHECKED	TS		
MFG. APPR.	TS		
APPROVED	TS		
DE APPR.	TS		
DATE	07.07.27		

DART AEROSPACE USA, INC.
PORT HADLOCK, WA
DRAWING NO. **D3639**
REV. A
SHEET 1 OF 2
TITLE **DOUBLER**
SCALE 2:3
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D

C

B

A

8 7 6 5 4 3 2 1

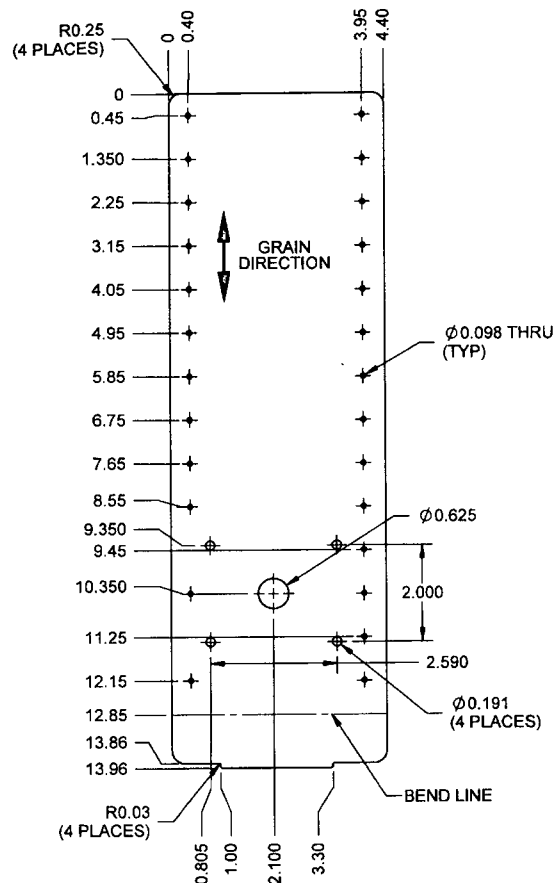
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

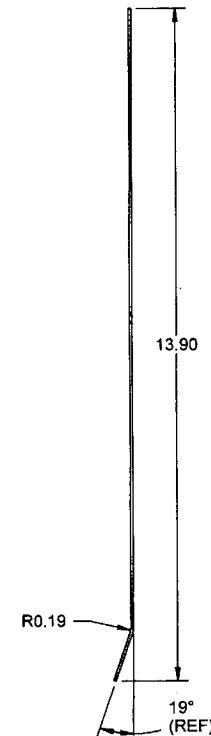
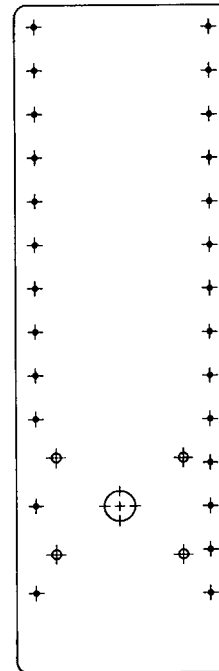
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**D3639-3F FLAT PATTERN
(D3639-4F OPPOSITE)**



**D3639-3 DOUBLER
(WAS GENEVA P/N G10604-4)
D3639-4 OPPOSITE
(WAS GENEVA P/N G10604-5)**

76278

RELEASED
07.09.07

- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-3/-4" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.3 lbs

DESIGN	TS	DART AEROSPACE USA, INC.	
DRAWN	LE	PORT HADLOCK, WA	
CHECKED	BE	DRAWING NO.	REV. A
MFG. APPR.	BE	D3639	SHEET 2 OF 2
APPROVED	BE	TITLE	SCALE
DE APPR.	BE	DOUBLER	2:5
DATE	07.07.27	<small>COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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